

Work Order ID 59819

Friday, June 11, 2010 12:56:00 PM



Page 1

Item ID: D350-689-011

Accept



Setup Start



Revision ID:

Item Name: Dual High Back Seat

Stop



Start Date: 6/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-6-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9498

A

IIN-D350-689

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-689-011 CHG003

S 11/01/04

CK Per Bar 11/01/04

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/1/4 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59819

Friday, June 11, 2010 12:56:00 PM



Page 2

Item ID: D350-689-011

Accept



Setup Start



Revision ID:

Item Name: Dual High Back Seat

Stop



Start Date: 6/11/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				(x6)			
130 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-689-011 Location: 112 PPP Rev: F	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/1/4 SP

CK 11/01/07
ME
10-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 11, 2010 12:56:07 PM

Page 1

Work Order ID: 59819

Parent Item: D350-689-011

Parent Item Name: Dual High Back Seat

Comments: IPP Rev:B 03.05.09 Reformat; Modify Step 1 KJ/RF IPP Rev:C chg003 per
DSI 9498 DD 10.02.11 verified by:JLM

Start Date: 6/11/2010

Required Date: 7/5/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S D3018-1 Seat Cushion		Manufactured	No			110	Each	1.0000	1	1		11/1/4	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST420A		1							
				44153		1							
S D3019-1 Seat Cushion		Manufactured	No			110	Each	1.0000	1	1		11/1/4	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST420A		1							
				44154		1							
S D350-689-013 CHG002 Floor Provisions		Manufactured	No			110	Each	0.0000	1	1		11/1/4	
S D350-689-041 Dual High Back Seat Ass'y		Manufactured	No			110	Each	0.0000	1	1		11/1/4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY**25.5 WEIGHT AND BALANCE**

The following weight and balance information is for the Dart Dual High Back Seat Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011	27.0 lb	-18.2 in	-491 in-lb	60.7 in	1639 in-lb
Dual High Back Seat Installation	12.2 kg	-0.46 m	-5.6 m-kg	1.54 m	18.8 m-kg
D350-689-013	2.0 lb	-18.2 in	-36 in-lb	60.7 in	121 in-lb
Floor Provisions Kit	0.9 kg	-0.46 m	-0.4 m-kg	1.54 m	1.4 m-kg

25.6 PARTS LIST

Qty		Part Number	Description
X		D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X	D350-689-013	FLOOR PROVISIONS KIT
1	X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
	2	D3016-041	SEAT FRAME ASSEMBLY
	1	D3017-041	BACK FRAME ASSEMBLY
1		D3018-1	SEAT CUSHION
1		D3019-1	BACK CUSHION
	1	D3021-041	TUBE ASSEMBLY
	1	D3022-1	SEAT PAN
	1	D3023-1	BACK PANEL
	3	D3024-1	SPACER
1		D3025-1	BEAM
1		D3026-1	CHANNEL
1		D3027-1	CLIP
1		D3027-3	CLIP
1		D3027-5	CLIP
4		D3027-7	CLIP
	4	D3028-1	STUD
	2	D3029-1	SPRING
	2	D3030-1	LOCK
	2	D3031-1	LOOP
1		D3032-1	SPACER
1		D3033-1	SEAT TRACK
1		D3033-3	SEAT TRACK
6	23	AN960JD10L	WASHER
	3	AN3-12A	BOLT
16		MS20426AD3-6	RIVET
17		MS20426AD4-6	RIVET
18		MS20470AD4-5	RIVET
2		MS20470AD4-6	RIVET
30		MS20470AD5-6	RIVET
	46	MS20600AD4W2	RIVET
8		MS21059L3	NUTPLATE
6		MS27039-1-10	SCREW
	4	MS27039-1-17	SCREW
	12	MS27039-1-19	SCREW
	4	MS24693-S272	SCREW
2		MS24693-S273	SCREW
	23	MS21042L3	NUT (OR MS21042-3)

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25-00-00

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV 0

REF TCCA STC: SH02-33

REF FAA STC: SR01620NY

REF EASA STC: EASA.IM.R.S.01453

REF BRAZILIAN STC: 2005S03-09

REFERENCE ONLY

PURPOSE:

TO UPDATE THE PARTS LIST AND THE WEIGHT AND BALANCE TABLE IN IIN-D350-689 REV A AND ICA-D350-689 REV 0.

CHANGE:

FOR D350-689-011 AT CHANGE 003, D350-689-021 AT CHANGE 002, D350-689-041 AT CHANGE 002 AND D350-689-043 AT CHANGE 002, QTY (6) OF: MS27039-1-19 SCREW; MS21042L3 NUT & AN960JD10L WASHER REPLACED WITH QTY (6) OF: MS27039-4-21 SCREW; MS21042L4 NUT & NAS1149D0432J WASHER RESPECTIVELY. FIGURE 6 (PG 9) OF IIN-D350-689 MODIFIED PER SHT 2 OF THIS SERVICE INSTRUCTION. THE HARDWARE SECTION OF THE PARTS LIST IN SECTION 5 (PG 10) OF IIN-D350-689 REV A & SECTION 25.6 (PG 31) OF ICA-350-689 REV 0 IS AMENDED AS FOLLOWS:

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X						D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X					D350-689-013	FLOOR PROVISIONS KIT
		X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH (REF DSI 9419)
		1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISION KIT (REF DSI 9419)
1				X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY (REF DSI 9419)
	6			17	17	NAS1149D0332J	WASHER (OR AN960JD10L)
			9			NAS1149D0363J	WASHER (OR AN960JD10)
				6	6	NAS1149D0432J	WASHER (OR AN960JD416)
				3	3	AN3-12A	BOLT
16						MS20426AD3-6	RIVET
			14			MS20426AD4-5	RIVET
17						MS20426AD4-6	RIVET
18			34			MS20470AD4-5	RIVET
2			18			MS20470AD4-6	RIVET
30			32			MS20470AD5-6	RIVET
				40	40	MS20600AD4W2	RIVET
				6	6	MS20600AD4W3	RIVET (REF DSI 9349)
8						MS21059L3	NUTPLATE
6						MS27039-1-10	SCREW
				4	4	MS27039-1-17	SCREW
				6	6	MS27039-1-19	SCREW
				6	6	MS27039-4-21	SCREW
				4	4	MS24693-S272	SCREW
2						MS24693-S273	SCREW
					8	MS24694-S3	SCREW
			9			MS24694-S50	SCREW
					4	MS24694-S148	SCREW
			9	17	17	MS21042L3	NUT (OR MS21042-3)
				6	6	MS21042L4	NUT (OR MS21042-4)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.01.21
CERT. NO.: SH02-33
ISSUE NO.: 1

A	NEW ISSUE.	JPH	10.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. A DSI 9498 SHEET 1 OF 2 TITLE SCALE SEAT REINF; IIN & ICA UPDATE NTS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.21		
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A

REF TCCA STC: SH02-33

REF FAA STC: SR01620NY

REF EASA STC: EASA.IM.R.S.01453

REF BRAZILIAN STC: 2005S03-09

REFERENCE ONLY

PURPOSE:

TO PROVIDE AN OPTIONAL CONTROL GUARD KIT TO BE INSTALLED ON THE D350-689-011/-021 DUAL HIGH BACK SEAT INSTALLATIONS.

CHANGE:

OPTIONAL D350-689-019 CONTROL GUARD KIT ADDED AS DETAILED BELOW. WHEN INSTALLING THE AN4 BOLTS IN THE DART SEAT, DRILL QTY (2) Ø0.257" HOLES PER INSTRUCTIONS (SEE SHEET 2 DETAIL A OF THIS SERVICE INSTRUCTION FOR REFERENCE).

Qty -011	Qty -013	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X							D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X						D350-689-013	FLOOR PROVISIONS KIT
		X					D350-689-019	CONTROL GUARD KIT
			X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH (REF DSI 9419)
			1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISION KIT (REF DSI 9419)
1					X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
			1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY (REF DSI 9419)
		1					D3084-3	STRUT
		2					NAS43DD4-46N	SPACER
		1					AN4-12A	BOLT
		1					AN4-20A	BOLT
		2					MS21042-4	NUT (OR MS24042L4)
		8					NAS1149D0416J	WASHER

INSTRUCTIONS:

1. LOCATE LOWER HOLE (SEE FIGURE 1 SHEET 2) AND DRILL Ø0.257" HOLE.
2. USING STRUT P/N D3084-3 AS TEMPLATE, TEMPORARILY FASTEN TO LOWER HOLE, LOCATE UPPER HOLE ON CENTER LINE OF TUBE. REF FIGURE 1.
3. DRILL Ø0.257" HOLE.
4. REMOVE BURRS AND SHARP EDGES ON BOTH HOLES AND TOUCH UP PER ICA-D350-689 CHAPTER 5.2 SECTION 8.
5. INSTALL STRUT USING HARDWARE SHOWN. TORQUE FASTENERS TO 50-70 in-lbs.
6. LONGER AN4 BOLTS ARE ACCEPTABLE TO ENSURE A MINIMUM OF 1.5-2 THREADS IN SAFETY.

WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-019 CONTROL GUARD KIT. (Seat's Fwd position)	0.5 lb 0.23 kg	-9.0 in -0.23 m	- 4.5 in-lb -0.05 m-kg	60.7 in 1.54 m	30 in-lb 0.35 m-kg
D350-689-019 CONTROL GUARD KIT. (Seat's Aft position)	0.5 lb 0.23 kg	-9.0 in -0.23 m	- 4.5 in-lb -0.05 m-kg	64.7 in 1.64 m	32 in-lb 0.38 m-kg

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.04.01
CERT. NO.:	SH02-33
ISSUE NO.:	1

A	NEW ISSUE.	JPH	10.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9493	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INSTALLATION OF CONTROL GUARD NTS	
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